

Date: Tuesday, 10/06/2008 9:55:15 AM
User: Julie Lecocq

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D350-636-013
Job Number : 39751	
Estimate Number : 10804	
P.O. Number :	Part Number : D350636013
This Issue : 10/06/2008 S.O. No. :	Drawing Number : R08-052
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SKIDTUBES	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 17/06/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.12.10</u>	
Comment :	

Additional Product

DART		TEL.: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D350-636-013	CHG	CHG003
DESC.	Skidtube Assembly	STC	SH99-7
LOT	B38847	STC	SR00646SE
MODEL	AS350/355	STC	
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

Job Number:



Seq. #: Machine Or Operation:

Descr

1.0 D350636013 Skidtube LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Skidtube LH
Original B38847 @ CHG003

2.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Remove the following items and restock using the original batch#:

- 2x D3537-1 B36426 ✓
- 1x D3535-13 B37584 ✓
- 1x D3536-13 B36635 ✓
- 1x D3535-35 B36425 ✓
- 1x D3536-35 B38183 ✓
- 1x AN960C816L washer M104093 ✓
- 2x NAS1515H8L washer---Discard. ✓

Replace
(x) M521083-E8
M107939

gl
08-06-17 (X1)

Reassemble the skidtube as per DSI9413 Rev.A, and pick the following:

Sikaflex M: 107893 A/R 08/10

4.0 D37941 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Gasket B39421

gl 08-06-17 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 9:55:16 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-013

Job Number: 39751

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	D37931	Wearshoe
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe B39715 JH

6.0	D37911	Wearplate
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate B39418 JH

7.0	D37943	Gasket
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket B39422 JH

8.0	D37933	Wearshoe
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe B39479 JH *

9.0	AN3C5A	Bolt
-----	--------	------



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)
Bolt M108077 JH

10.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)
washer M1108077 JH

11.0	D36721	Phenolic Washer
------	--------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Phenolic Washer B39275 JH

12.0	AN526C1032R10	Screw
------	---------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw M108062 JH

08-06-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 9:55:16 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-013

Job Number: 39751

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

M 108079

JK

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Apply LPS Procyon to all exposed hardware. M 104251 A/R

JK 08-06-17 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Put tube back with the original kit.

So8/06/17 @

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New labels and paperwork required with the new batch # and most current change #.

Inspect kit, paperwork, and labels for completeness.

449004

So8/06/18

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

So8/06/18 @

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Repackage and return to stock.

Location:

Rev G

8/6/18

SP

(X)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/03 JK

Job Completion



u 08-07-03

B39751

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

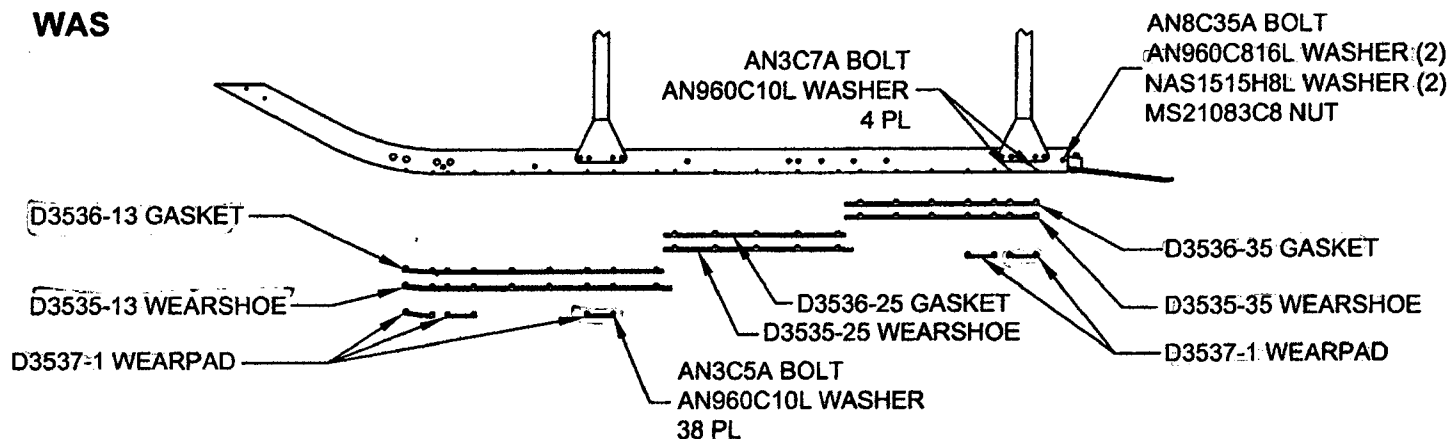
TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

REF CANADIAN STC: SH99-7

THE WEARPLATES ON D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 (AND LATER) HAVE BEEN MODIFIED AS SHOWN IN FIGURE 1 BELOW TO ELIMINATE THE POSSIBILITY OF INTERFERENCE BETWEEN THE WEARPLATES AND CROSSTUBE SADDLES AT INSTALLATION. THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

WAS



NOW

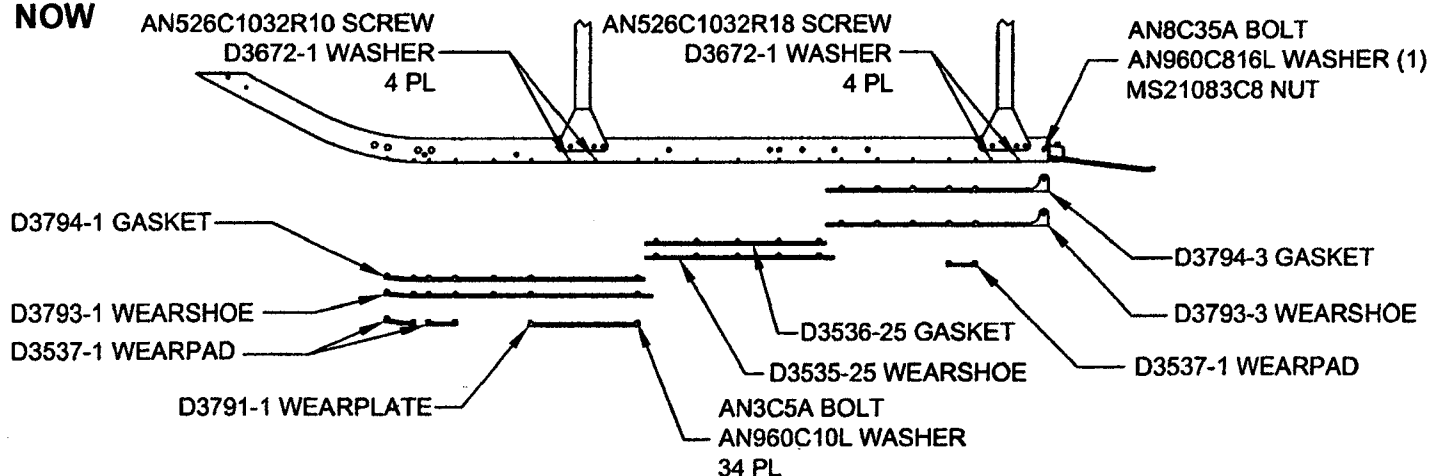


FIGURE 1 - WEARPLATE MODIFICATION

(AN526C1032RXX SCREW LOCATIONS NO LONGER USED TO MOUNT WEARSHOES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39751

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE MODIFICATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004, AMEND PARTS LIST OF IIN-D350-636 SECTION 5 AS FOLLOWS:

REMOVE:

Item	Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
	X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
*6A	1	1	1	1	AN960C816L	WASHER
6B	2	2	2	2	NAS1515H8L	WASHER
*22	2	2	2	2	D3537-1	WEARPAD
23A	1	1	1	1	D3535-13	WEARSHOE
23B	1	1	1	1	D3536-13	GASKET
25A	1	1	1	1	D3535-35	WEARSHOE
25B	1	1	1	1	D3536-35	GASKET
*26A	4	4	4	4	AN3C5A	BOLT
*26B	4	4	4	4	AN3C7A	BOLT
*27	8	8	8	8	AN960C10L	WASHER

*SUBTRACT FROM TOTAL QUANTITY OF PARTS INDICATED IN INSTALLATION INSTRUCTIONS IIN-D350-636

ADD:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
	X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
			X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
8	8	8	8	D3672-1	WASHER
4	4	4	4	AN526C1032R10	SCREW
4	4	4	4	AN526C1032R18	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39151

DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE MODIFICATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

TO IMPROVE THE INSTALLATION OF D350-636-011/-012/-013/-014 SKIDTUBES EQUIPPED WITH STAINLESS WEARPLATES/WEARPADS AND GASKETS (CHG 003) ONTO THE CROSSTUBES, THE FOLLOWING DSI 9413-011 WEARSHOE KIT CAN BE PROCURED FROM DART:

Qty -011	Part Number	Description
X	DSI 9413-011	WEARSHOE MODIFICATION KIT
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
8	D3672-1	WASHER
4	AN526C1032R10	SCREW
4	AN526C1032R18	SCREW

TO INSTALL THE DSI 9413-011 KIT, REMOVE THE EXISTING WEARSHOES/GASKETS UNDER THE FWD/AFT SADDLES AND INSTALL NEW WEARSHOES/GASKETS AS SHOWN IN FIGURE 1. PLUG UNUSED HOLES WITH AN526C1032RXX SCREWS AND D3672-1 WASHERS. INSTALL SCREWS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT AS SHOWN IN FIGURE 1. NOTE: SOME OF THE PREVIOUSLY INSTALLED HARDWARE IS NO LONGER REQUIRED.

THE FOLLOWING D350-636-045 REPLACEMENT WEARPLATE KIT WILL BE AVAILABLE FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 OR LATER:

Qty -011	Part Number	Description
X	D350-636-045	WEARSHOE KIT
3	D3537-1	WEARPAD
1	D3535-25	WEARSHOE
1	D3536-25	GASKET
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
34	AN3C5A	BOLT
34	AN960C10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 99751

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE MODIFICATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Date: Tuesday, 10/06/2008 8:11:19 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 38845	Customer	: Dart Helicopters Services
Estimate Number	: 13104	DWG Name	: WEARSHOE KIT
Purchase Order #	:	Part Number	: D350636043
Complete Date	: 29/04/2008 12:43:35	DWG Number	: N/A
		Rev.	: E

DUE DATE	ORDERED	DELIVERED
29/04/2008	1	1

3.0 D35371-Wearpad	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
29/04/2008	LACE01: Lacelle, Linda	D35371	5.000	\$54.02	Lot # 36426 Qty. 5
Subtotal:	QTD:	0	CTD:	5	\$54.02

4.0 D353513-Wearshoe	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
29/04/2008	GREG01: Gregory, Marc	D353513	1.000	\$9.01	Lot # 37584 Qty. 1
Subtotal:	QTD:	0	CTD:	1	\$9.01

5.0 D353613-Gasket	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
29/04/2008	GREG01: Gregory, Marc	D353613	1.000	\$3.85	Lot # 36635 Qty. 1
Subtotal:	QTD:	0	CTD:	1	\$3.85

6.0 D353525-Wearshoe	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
29/04/2008	GREG01: Gregory, Marc	D353525	1.000	\$14.13	Lot # 38162 Qty. 1
Subtotal:	QTD:	0	CTD:	1	\$14.13

7.0 D353625-Gasket	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
29/04/2008	GREG01: Gregory, Marc	D353625	1.000	\$2.62	Lot # 38565 Qty. 1
Subtotal:	QTD:	0	CTD:	1	\$2.62

8.0 D353535-Wearshoe	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
29/04/2008	GREG01: Gregory, Marc	D353535	1.000	\$13.79	Lot # 37625 Qty. 1
Subtotal:	QTD:	0	CTD:	1	\$13.79

9.0 D353635-Gasket	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
29/04/2008	GREG01: Gregory, Marc	D353635	1.000	\$1.72	Lot # 38183 Qty. 1
Subtotal:	QTD:	0	CTD:	1	\$1.72

10.0 AN3C5A-Bolt	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
29/04/2008	GREG01: Gregory, Marc	AN3C5A	38.000	\$13.49	Lot # 107737 Qty. 38
Subtotal:	QTD:	0	CTD:	38	\$13.49

11.0 AN3C7A-BOLT	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
29/04/2008	GREG01: Gregory, Marc	AN3C7A	4.000	\$1.60	Lot # 107376 Qty. 4
Subtotal:	QTD:	0	CTD:	4	\$1.60

Date: Tuesday, 10/06/2008 8:11:19 AM
User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 38845	Customer	: Dart Helicopters Services
Estimate Number	: 13104	DWG Name	: WEARSHOE KIT
Purchase Order #	:	Part Number	: D350636043
Complete Date	: 29/04/2008 12:43:35	DWG Number	: N/A
		Rev.	: E

12.0 AN960C10L-washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
29/04/2008	GREG01: Gregory, Marc	AN960C10L	42.000		\$2.50	Lot # 107823 Qty. 42

Subtotal: QTD: 0 CTD: 42 \$2.50

13.0 PACKAGING 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
29/04/2008	GREG01: Gregory, Marc	Run	1.000	2.33	\$36.23	3.20	0.00

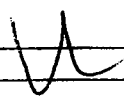
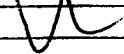
Subtotal: QTD: 1 CTD: 0 2.33 \$36.23

		TIME	COST
	Machine Time:	3.20	\$0.00
	Labor:	2.33	\$36.23
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$116.73
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$152.96

COST PER UNIT: \$152.96

Date: Monday, 28/04/2008 3:33:25 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : INSTALL D350-636-043
Job Number : 38847	
Estimate Number : 10804	
P.O. Number :	Part Number : D350636013
This Issue : 28/04/2008 S.O. No. :	Drawing Number : D350-636-013
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SKIDTUBES	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 29/04/2008 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



REFERENCE ONLY

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPP

CHG002 003

08/4/29 JLD

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D350-636-013 B 32529

08.04.28

3.0 D350636013 Skidtube LH



(1X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Skidtube LH

B 3 2 5 2 9 M-L 08/04/29

4.0 D350636043 Wearshoe



(1X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Wearshoe

B 3 8 8 4 5 M-L 08/04/29

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(1X)

Comment: HAND FINISHING RESOURCE #1
INSTALL D350-636-043 B

B 3 2 5 2 9 M-L 08/04/29

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INSTALL D350-636-043

Job Number: 38847

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/29 @

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RE-PACKAGE PER PPP

USING NEW B/N - CHG002 003

NEW LABELS REQ'D

Rev F 8/1/29

(X)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



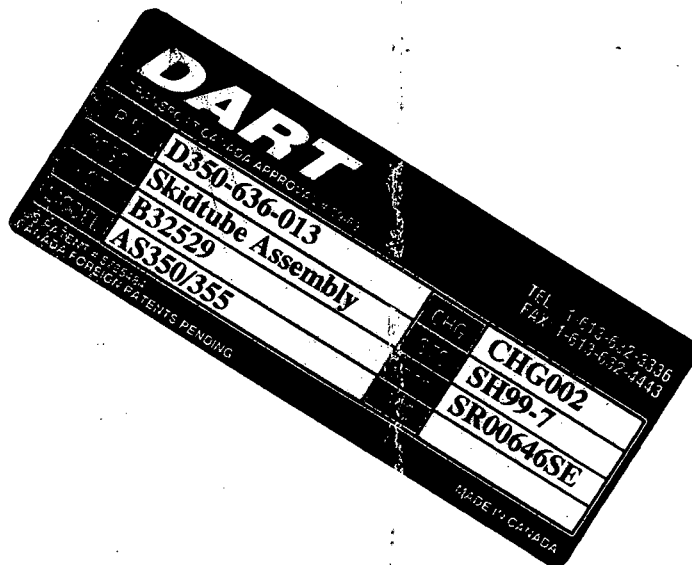
Comment: FINAL INSPECTION/W/O RELEASE

08/04/29

Job Completion



08-04-29



332529

25

Date: Wednesday, 5/23/2007 4:02:58 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
 Job Number : 32529
 Estimate Number : 10266
 P.O. Number : N/A Part Number : D350636013
 This Issue : 5/23/2007 S.O. No. : N/A Drawing Number : D2750 UNDER REVIEW 07.05.24
 Prsht Rev. : NC Project Number : N/A CB
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D
 Previous Run : 32528 Material : N/A Due Date : 6/20/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07.05.24
 Comment : Est Rev H 02.09.25 Rearranged procedure steps KJ
 est rev I 06.03.30 Per rev. D dwg EC

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 002

KS 07-06-04

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent) D30666

7-6-4

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch B 29784 BE 07-06-07

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

7-6-4

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

7-6-5

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

ston

Process Sheet

DU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

er: 32529

Part Number: D350636013



Machine Or Operation:

Description :

2-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M104989

EXP DATE: 08-01

3-Coat all exposed fasteners with "LPS Procyon" batch: M104251

07-08-07-01

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-08-08-01

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade

Batch: B30586-

44.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M104093-

45.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M104625-

46.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M104117-

5/23/2007 4:02:58 PM
ston

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

ser: 32529

Part Number: D350636013



Machine Or Operation: Description :

47.0 NAS1515H8L WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M104955 -

48.0 D34931 WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: B32600 -

49.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

51.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 207108109

B32529